

Date: Wednesday, 2/15/2006 3:50:33 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG BRACKET
 Job Number : 25867
 Estimate Number : 10010
 P.O. Number : N/A Part Number : D27353
 This Issue : 2/15/2006 S.O. No. : N/A Drawing Number : D2735 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : PURCHASED PARTS Drawing Revision : C
 Previous Run : N/A Material : N/A
 Written By : SEE COMMENT BELOW Due Date : 3/10/2006 Qty: 20 Um: Each
 Checked & Approved By : 06.02.16
 Comment : Est Rev: C Removed from 9 Digit 05-10-25 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 PG PURCHASING



Comment: PURCHASING

Issue P/O: 603

E-mail or Ship DXF file to vendor

Laser cut flat pattern as per Dwg D2735

Possible supplier: Ind. Laser

Material release note is required.

U 06-02-16 20

2.0 D27353F Lug Bracket



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Lug Bracket

3.0 PACKAGING 1. PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure material certification is attached

C 20602109

(52)

4.0 QC6 DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

Inspect dimensions per templates D2735-3T1 & DWG D2735

06-03-14

PTO

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

1-Form D2735-1 as per Dwg D2735. Use CNC Brake Jig DT8204

2-Deburr if required. SAD 06.07.20

(21)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
06-03-14	4	Took 1 for template D2753-3T1 (identified as) change template # to D2753-3T1 (Not -1T1)	<i>[Signature]</i>	06-03-14	1	<i>[Signature]</i>	<i>[Signature]</i> 06-03-14	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/15/2006 3:50:34 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG BRACKET

Job Number: 25867

Part Number: D27353

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



June 14.20

PTO

- Comment: INSPECT WORK TO CURRENT STEP

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *W521*

CPL 06-04-18

(20)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/20

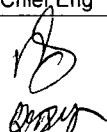



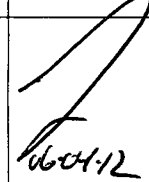
Job Completion



W 06-04-19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/04/20
 QA: N/C Closed: _____ Date: _____

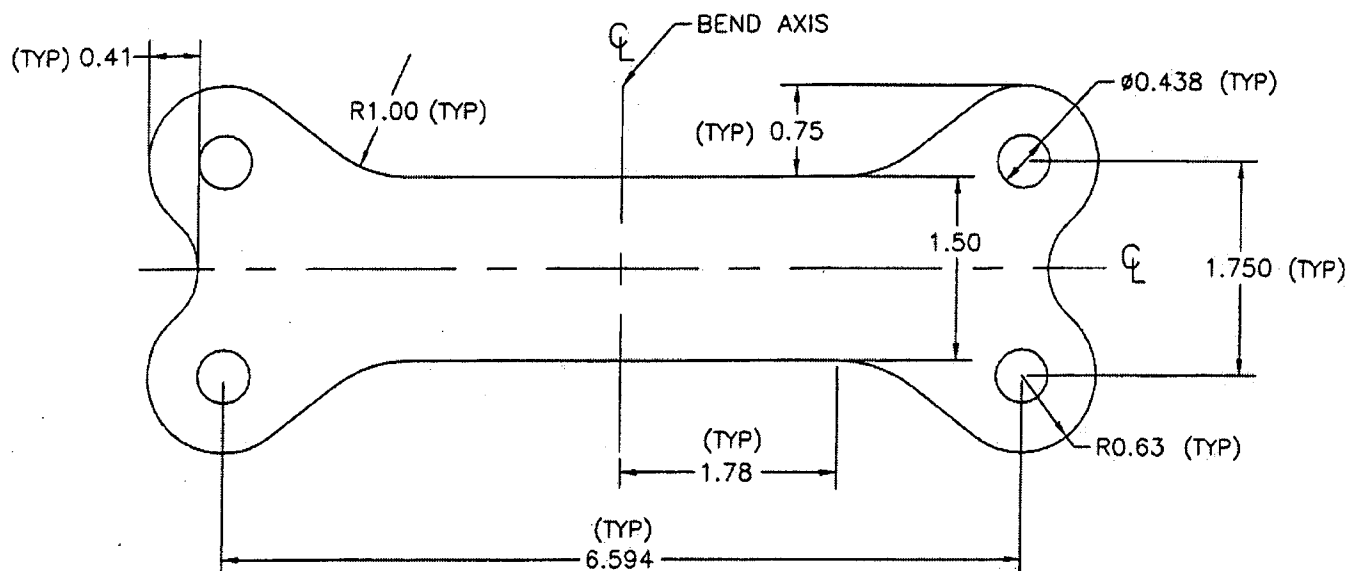
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
06-04-12	5-0	1 part scrap. Bends way out of tolerance on the ends & shape doesn't fit skid tube welding J.g.		Scrap: destroy	 06-04-12	 06-04-12		 06-04-12

NOTE: Date & initial all entries

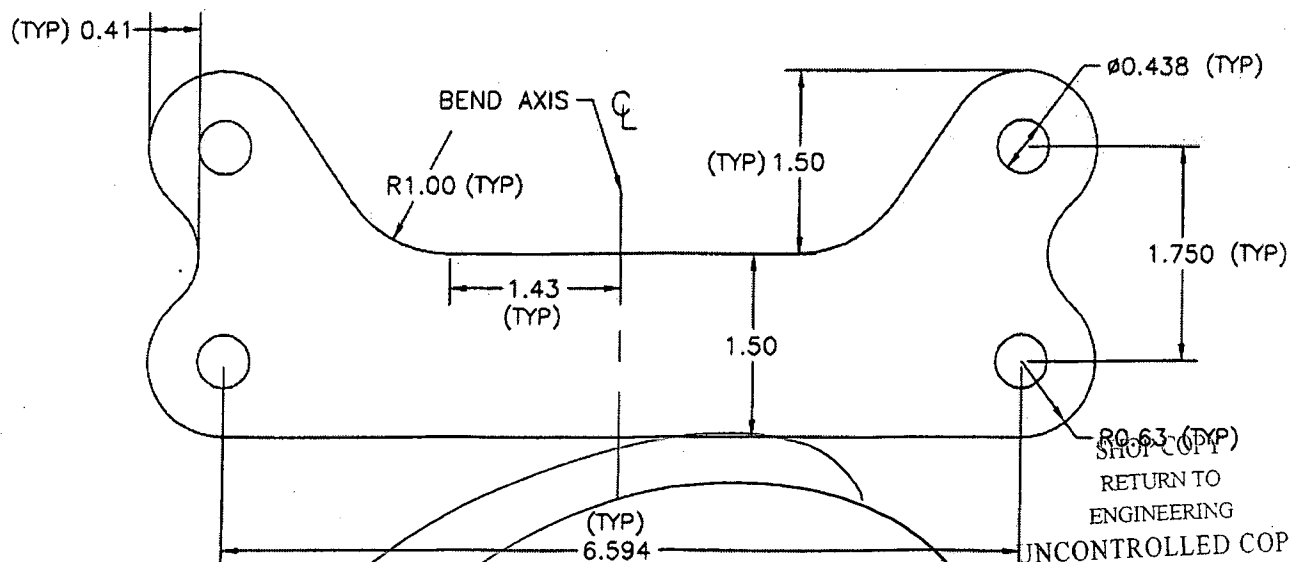


DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 1 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3
A	97.12.14	NEW ISSUE	
B	98.10.23	UPDATE MATERIAL (TSR A1114)	
C	98.12.14	REMOVE TOOLING HOLES (TSR A1040)	

RELEASED
98.12.14 DS



D2735-1 FLAT PATTERN
SYMMETRIC ABOUT BOTH CENTRE-LINES (CL)



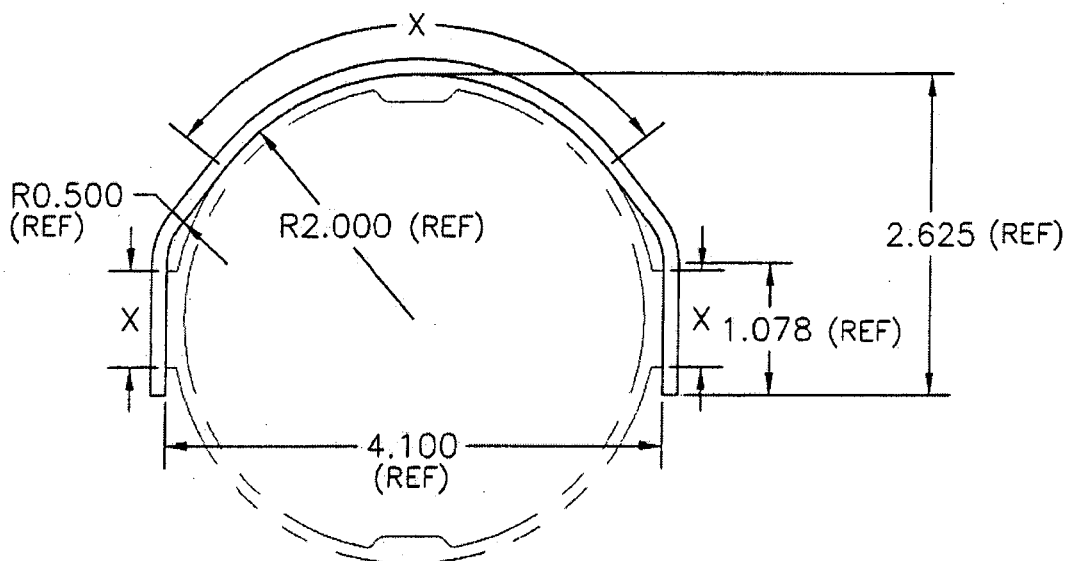
D2735-3 FLAT PATTERN
SYMMETRIC ABOUT CENTRE-LINE (CL)

STOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 25867



DESIGN <i>PH</i>	DRAWN BY <i>PH</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>CP</i>	APPROVED <i>KE</i>	DRAWING NO. D2735	REV. C SHEET 2 OF 2
DATE 98.12.14		TITLE LUG BRACKET	SCALE 2:3

RELEASED
98.12.14 DS



D2735-1 AND D2735-3 BEND DETAIL

D2735-1 AND D2735-3 SHOULD BE BENT TO WITHIN 0.010 OF THE OUTSIDE PROFILE OF THE D2500-1 EXTRUSION IN THE AREAS INDICATED 'X' ABOVE.

GENERAL NOTES

MATERIAL: ASTM A36/A366/A569/A570 OR AISI 1010-1025 STEEL
0.125 THICK (11 GAUGE)
MIN. ULTIMATE TENSILE STRENGTH = 42 ksi
MIN. YIELD TENSILE STRENGTH = 28 ksi

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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WITHOUT NOTICE
WORK ORDER
NO. 25867



New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8989 / 375 8111 Auckland
(09) 235 8089 / 235 3535 Waiuku
Fax: (09) 375 8999

TEST CERTIFICATE

Ref: 5746/25194

Reissued 1/12/2005

CUSTOMER		Wilkinson		P50916D1001		SPECIFICATION		ASTMA1908 CS Type A		CERTIFICATE No		TC122435														
CUSTOMER O/M		99-21N-963				PRODUCT		CRA WIDE COIL		PAGE		1 of 1														
MILL O/M		507683				DIMENSIONS		0.114" x 48" x Coil		DATE		29 November 2005														
PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTM A370)									
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE ()	BEND 180°	YIELD	T.S.	%ELONG G.L.=	HARDNESS HRB	r ()	LENGTH (feet)		
		x100			x1000												x10000		x100							
R9-471775-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				51		794		
R9-471776-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				51		682		
R9-471777-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				54		768		
R9-471778-00	644609	4	TR	20	8	11	11	17	23	1	6	1	1					Good				54		640		

P.02603

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 S ₀ (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r ₀ (C)=r ₄₅ (B)=r ₉₀ (D)=(r ₀ +r ₉₀ +2r ₄₅)/4	IMPACT TEST (A)=10mm x 10mm (B)=7.5mm x 10mm (C)=5mm x 5mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=
----------------------------------------------------------	---------------------------------------------------------------------------------------------	------------------------------------------------------------------------------------------------------------------------------------------------------	-----------------------------------------------------------------------------------------------------------	-------------------------------------------------------------------------------------------------------------

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED
WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED

Batish Misra

QC METALLURGIST